

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014094**Date Inspected:** 09-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: An Qing Xiang, Tu Jun
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: Tower

Bridge No: 34-0006**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10, North Tower lift 4, BC Corner Diagonal Stiffener

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSTL4-3B/L-49, 53, 17
NSTL4-3C/L-130
NSTL4-3F/L-128
NSTL4-3G/L-124
NSTL4-3H/L-122
NSTL4-3I/L-120
NSTL4-3J/L-122
NSTL4-3K/L-122

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This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER GRILLAGE PLATE

SMAW welding of weld joint 1A located on ESD1-TL5-2B/F.

Welder is identified as 040690. ZPMC QC is identified as Mr. Li Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

LIFT 4 STRUT PLATE

SMAW welding of weld joint 19 located on ND1-STSA4-6-135M-1.

Welder is identified as 251194. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 5B located on ND1-STSA4-6-127M-1.

Welders are identified as 046709. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 80 located on ED1-STSA4-6-123M-1.

Welder is identified as 040724. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

BAY 10

TOWER GRILLAGE PLATE

SMAW welding of weld joint 35A located on SSD1-TL5-1B-F.

Welder is identified as 500363. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

SMAW welding of weld joint 2A located on SSD1-TL5-1B-F.

Welder is identified as 500363. ZPMC QC is identified as Mr. Deng Zhi Bing.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

EXTERIOR DIAPHRAGM CONNECTION PLATE (WD1-A2-1)

During random in process inspection, this QA inspector observed that ZPMC personnel was performing buttering of about 5mm~14.5mm on the edge of exterior diaphragm connection plate of WD1-A2-1. Welders are identified as 057180 & 053116. ZPMC Cwi is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
